

Work Order ID 71966

Thursday, July 14, 2011 11:21:41 AM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

11-07-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

11 07 20 (4)
for BG 11-7-20 (4)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/19 5/ (42)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11 n 07 20 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>22</u>								
	PPP Rev: <u>22</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

Sup 7/21

(4x)

11/7/21

mf

11-07-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, July 14, 2011 11:21:57 AM

Page 1

Work Order ID: 71966

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

66.0000

2

8

Screw

Location

Loc Qty

Loc Code

MEZZ

2

113064

1

113749

1

ST328

64

116304

64

AN526C832R8

Purchased

No

120

Each

143.0000

8

32

Screw

Location

Loc Qty

Loc Code

ST327

143

116471

2

117688

41

117735

100

AN526C832R9

Purchased

No

120

Each

375.0000

8

32

Screw

Location

Loc Qty

Loc Code

ST327

375

117010

7

117628

368

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

0.0000

4

16

Washer

1117505 11/7/20 42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, July 14, 2011 11:21:58 AM

Work Order ID: 71966

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD8- NAS1149DN832J Purchased No

120 Each

0.0000

24 96

Washer

D2143

Manufactured No

120 Each

26.0000

1 4

Hinge Bracket

Location

Loc Qty

Loc Code

ST198

26

64308

26

Manufactured No

120 Each

15.0000

1 4

D2144

Hinge Bracket

Location

Loc Qty

Loc Code

ST198

15

64778

15

Manufactured No

120 Each

39.0000

2 8

D2150

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

39

69514

39

Manufactured No

120 Each

33.0000

2 8

D2151

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

33

64776

7

69515

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00



Door Prop

Manufactured No

120 Each

47.0000



4

Location

Loc Qty

Loc Code

ST272

47

64943

11

71003

36

Manufactured No

120 Each

29.0000



4

Location

Loc Qty

Loc Code

ST006

29

64312

29

Manufactured No

120 Each

54.0000



8

Location

Loc Qty

Loc Code

ST009

54

66139

16

70558

38

Manufactured No

120 f

158.7200

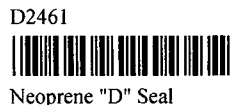
7.25

30.52632



11/1/20

SP (4)



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

158.72

39782

6.5

55054

4

63880

148.22

measured
8/11/20
cut 1' X 87.00"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, July 14, 2011 11:21:59 AM

Work Order ID: 71966

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

D2463

Manufactured No

120 f

378.6030

7.25

30.52632

Seal

Location

Loc Qty

Loc Code

ST404

378.603

64944

10.21

66954

368.393

cut 1 X 87.00"

D2583

Manufactured No

120 Each

47.0000

2

8

Latch Bracket

Location

Loc Qty

Loc Code

ST017

47

69512

7

70559

40

D2585

Manufactured No

120 Each

75.0000

2

8

Mounting Channel

Location

Loc Qty

Loc Code

ST017

75

69536

19

70814

56

D2586

Manufactured No

120 Each

98.0000

6 2

8

Door Latch

Location

Loc Qty

Loc Code

ST204

98

64774

48

70557

50

Thursday, July 14, 2011 11:21:59 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, July 14, 2011 11:21:59 AM

Work Order ID: 71966

Parent Item: D350-588-011



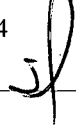


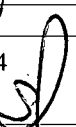


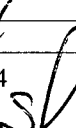


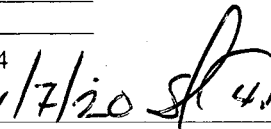
Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

 Door Slug, 350 Hinge	Manufactured	No	120	Each	14.0000		4	
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
	ST017		14					
		<u>66836</u>		14				
 Keys, Key Chain, 350 Hinge	Manufactured	No	120	Each	88.0000		4	
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
	ST018		88					
		<u>58194</u>		88				
 Cable	Manufactured	No	120	Each	17.0000		4	
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
	ST020		17					
		<u>66510</u>		17				
 Hinge Bracket	Manufactured	No	120	Each	18.0000		4	
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
	ST024		18					
		<u>66983</u>		18				
		<u>2</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 71966

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

D2857-2
Hinge Bracket

Manufactured No

120 Each

38.0000

1 4

Location

Loc Qty

Loc Code

ST024

38

64463

4

65091

10

67001

24

3

D2858-1
Hinge Bracket

Manufactured No

120 Each

6.0000

1 4

Location

Loc Qty

Loc Code

ST024

6

64785

6

4

D2858-2
Hinge Bracket

Manufactured No

120 Each

6.0000

1 4

Location

Loc Qty

Loc Code

ST024

6

64787

6

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Thursday, July 14, 2011 11:22:00 AM

Work Order ID: 71966

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

FG-778150-550-ROL

Purchased

No

120

sf

2,480.811

1

4

7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

CA

1499.811

117602

1499.811

ST404

981

104845

3

108932

18

111166

392

113905

568

1- cut 1 squarre ft of glass cloth

MS20426AD3-4

Purchased

No

120

Each

5,128.000

12

48

RIVET

Location

Loc Qty

Loc Code

ST316

5128

104374

1142

110398

3986

MS20470AD4-5

Purchased

No

120

Each

561.0000

18

72

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

561

116893

561

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 71966

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L08

Purchased

No

120

Each

385.0000

18

72



Nut

Location

Loc Qty

Loc Code

ST300

385

117441

3

117601

22

117677

10

117739

150

118242

200

MS21042L3

Purchased

No

120

Each

1,666.000

4

16



Nut

Location

Loc Qty

Loc Code

ST300

1666

116549

28

117441

800

117601

400

117885

438

MS27039-08-11

Purchased

No

120

Each

169.0000

6.2

8



Screw

Location

Loc Qty

Loc Code

ST290

169

116289

19

117441

150

Thursday, July 14, 2011 11:22:00 AM

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 71966



Parent Item: D350-588-011



Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15
Screw



Purchased

No

120

Each

57.0000

6 2

8

11/7/2011 (40)

Location

Loc Qty

Loc Code

ST292

57

116916

32

118093

25

8

Thursday, July 14, 2011 11:22:00 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00